Work Ord				*194	4371*							Page	1
Item ID: Revision ID: Item Name:	D3414-041 Lug			Accept	*N900)040	100	n *	Setup	Start Stop	1 /1	S1* S2*	
Start Date: Required Date Reference:	9/10/14 :: 9/10/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item Customer:								
Approvals:		n: MCJ	Date:	Tooling: _ SPC (Y/N):		Pate:			Run	Start Stop	"171	R1*	
Sequence ID/ Work Center I	(D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej		Reject Number	Insp. Stamp	
Draw Nbr D3414	Revi Rev	c C											
*100 *100 Waterjet FLOW CNC Water	jet	Memo 1-Cut as p Dwg Rev:	er Dwg D3414-1	0.00				8			De l'	1/10/10	DAS 23 9-89
		Prog Rev:_ 2-Deburr i											
*110 *110* QĈ		QC2- Inspect parts off Memo	machine FAI/FAIB	0.00				8			De!	14/10/10	DAS 23 9-89

Quality Control

DQA:		Date:						_				DART
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		ork Order up	date only	AEROSPACE
an closed.	 	Dutc.										
Work Orde	er:				DISPOSITION	1			AGAINST DE	PARTMENT	PROCESS	
					Rework			Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite	_	Supplier	
Root				Desci	ription of work order update	ı	nitial	Act	ion	Sign &	-	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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						FA	ULT CA	TEGORY		·		
· Landii	ng Gear				General] <i></i>			Outside Dim	onsions [Pressure/Forced
	Bending				Bend	\vdash	1	Program		Over/Under	 	Set-up
	Centre N	ot Conce	ntric	-	BOM/Route	-	Grain		 	Part Incorre	_	Temperature/Cure
	Cracks			\vdash	Broken/Damage/Defect	\vdash	Hardwa			Part Lost/Mi) -	- Weld
	Crimp/Ki	nk/Rippie	e/Wave		Burrs	\vdash	4 '	ion Incomplete/Ur	· –	Part Moved		Wrong Stock Pulled
	Cuffs			-	Contamination	-	4	tions Incomplete/l	Jilcieai –	Positioned V	L. Vrong	
	Crushing			-	Countersink	\vdash	Mislab	gned/off center	}_	Power Loss/		Other
	Heat Tre		. Tl	<u> </u>	Cut Too Short	\vdash	Misrea		<u>L</u>	Trowel ross/	Juige _	Other
	Inspection		ııupe	\vdash	Drawing Drill Holos	\vdash	1					
	Marks/C			<u> </u> -	Drill Holes	-	Off-set					
	Turning			-	Finish	 	4	Calibration				
	Wave/Tv	vist in Tu	pe	L	Fit/Function		Jout of	Sequence				

Work Ord September-11-1				*124	1371*					Page 2
Item ID: Revision ID: Item Name:	D3414-041 Lug			Accept	*N900	004010	N *	Setup Star		S1* S2*
Start Date: Required Date: Reference:	9/10/14 : 9/10/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item 1 Customer:	ID:			IVA	12
Approvals:		an:		Tooling: SPC (Y/N):		ate:		Run Star Stoj	^ \\	₹1* ₹2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept		Reject	Insp.
1 20 QC		QC8- Inspect parts - seco	ond check	0.00		Code	Qty	Qty	Number	Stamp DAS 38 9-89 14-10-1
Quality Control				<u></u>				<u> </u>	-	8.
130 *130*				0.00		DAS 30	গ			14/10
Brake NC Brake NC		Memo 1-Deburr 2-Form using	g DT8254 as per Dwg	0.00 D3414		9-89	-b			(100)
140 *1 Large Fab				0.00			${\mathcal B}$	/9	1-11-26	6 MAL

0.00

1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: M 133823

Large Fab

DQA:			Date:										•	"DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPD		Vο	rk Order up	date only	AEROSPACE
QA Closed.			Date.									·		
Work Ord	er:					DISPOSITION				AGAINSI L	JEP	PARTMENT	PROCESS	
-	•					Rework			Skid-tube (Crosstube igl[Water Jet	Engineering
Part i	۱o.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
				*		Use-as-is		Therr	noforming	Finishing	╝	Rec/Stor	e/Packaging	Other
NCR I	۱٥.					Suspected Unapproved			Large Fab C	Composite			Supplier	
Root					Desci	ription of work order update		nitial	Action		\neg	Sign &	· .	
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	<u> </u>	Bending			_	Bend	<u> </u>		Program	}	-	Outside Dim	-	Pressure/Forced
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route	_	Grain		-	-	Over/Under		Set-up
	L	Cracks				Broken/Damage/Defect	\vdash	Hardwa				Part Incorre	-	Temperature/Cure
		Crimp/Kir	nk/Ripple	e/Wave		Burrs	\vdash		ion Incomplete/Unqu	<u> </u>	_	Part Lost/Mi	issing	Weld
	<u> </u>	Cuffs			<u> </u>	Contamination	_	4	tions Incomplete/Unc	lear	-	Part Moved	L	Wrong Stock Pulled
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	_	Heat Trea			·	Cut Too Short	—	Mislab		F		Power Loss/	Surge	Other
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	_	Marks/Ch				Drill Holes	<u> </u>	Off-set						,
	<u> </u>	Turning S	-		<u> </u>	Finish	_	-	Calibration					
-	1	Wave/Tw	ist in Tul	эe		Fit/Function	1	Out of	Sequence					

3

Work Ord September-11-1				*12	4371*		,		.,			Page 3
Item ID: Revision ID: Item Name:	D3414-041		-	Accept	*N9000	140	100)*	Setup	Start Stop	· 1 VI .	S1*
Start Date: Required Date Reference:	9/10/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item ID Customer:) :				-	"IXI;	S2*
Approvals:		an:			Dat				Run	Start Stop		R1* R2*
Sequence ID/ Work Center I 150 *150*	D	Operation Description QC9- Inspect visual per (QS1004- Fusion Welds	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	ot Rej Qty		Reject Number	Insp. Stamp
QC Quality Control	<u> </u>	Мето		0.00	1901413	1		<u>o</u>		<u> </u>		:
160 *1 6 0*		QC5- Inspect part comple	eteness to step on W/O	0.00	PC1415	3,8	,	8				
Quality Control		Memo	·	0.00								
170 *170* Powdercoat		White Gloss(Ref:4.3.5.1) Memo	per QSJ005 4.3-Alum	0.00				8	ø	p-1-1	D 15.	S 8 8
Powder Coating		START TIM OVEN TEMI FINISH TIMI	PERATURE: 700	-								

DQA:		Date:											•	DART
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QA Closed.		Date.	· · · · · · · · · · · · · · · · · · ·	· · ·									l	
Work Orde	er:				DISPOSITION				AGAINST	DEI	PARTMENT	PROCESS		
					Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo				Scrap			Machining	Small Fab	Ш		d. Eng. Coor.		Quality
					Use-as-is		Therr	noforming	Finishing		Rec/Stor	e/Packaging	_	Other
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Root				Desci	ription of work order update	i	nitial	Acti			Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	_	QC Inspector
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	Bending				Bend	<u></u>	4 .	Program			Outside Dim		_	ressure/Forced
.a (c)	Centre N	ot Conce	ntric	L	BOM/Route	<u> </u>	Grain			}	Over/Under	<u>}</u>	_	et-up
748	Cracks				Broken/Damage/Defect		Hardw		;		Part Incorre		_	emperature/Cure
	Crimp/Ki	nk/Ripple	e/Wave		Burrs		4 '	ion Incomplete/Un	•	<u> </u>	Part Lost/Mi	ssing	┥	Veld
	Cuffs				Contamination	<u> </u>	4	tions Incomplete/L	Inclear		Part Moved	L		Vrong Stock Pulled
	Crushing				Countersink		Misali	gned/off center			Positioned V		_	
	Heat Tre	at			Cut Too Short	_	Mislab				Power Loss/	Surge	C	Other
	Inspection	n Strip in	Tube		Drawing	<u></u>	Misrea							
	Marks/C	hatter		<u> </u>	Drill Holes		Off-set							
	Turning 9				Finish		-{	Calibration						
	Wave/Tv	vist in Tul	be		Fit/Function		Out of	Sequence						

Work Ord September-11-1				*194	1371*							Page 4
Item ID: Revision ID: Item Name:	D3414-041			Accept	*N900	040	100)*	Setup	Start Stop	17	S1* S2*
Start Date: Required Date: Reference:	9/10/14 : 9/10/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:					- \-	
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description QC3- Inspect Part Finish	·	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
1 AN QC Quality Control		Memo	·	0.00				(8)			38 9-89 DEC 15 20
190 *100* Packaging		Identify as per dwg & Stoc	k Location:	0.00	-		DA ©6	- /	}			
Packaging		Мето					9-8				DEC 1	6 2014
²⁰⁰		QC21- Final Inspection - W	Vork Order Release	0.00					/	141	12/1	7 A
QC Quality Control		Memo		0.00			-			/ _/ .	1-11	

Apri-12/6

DQA:		Date:							ND 4 TE				*DART
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		Work Order	update only		AEROSPACE
					DISPOSITION				AGAINST (DEPARTME	NT/PROCESS		
Work Orde	r:				Rework			Skid-tube	Crosstube	\neg	Water Jet		Engineering
Part N	0.				Scrap			Machining	Small Fab		Prod. Eng. Coor.		Quality
NCR N	0				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/S	itore/Packaging Supplier		Other
Root			1	Desci	iption of work order update		nitial	Acti	ion	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verificatio	n	QC Inspector
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	Bending				Bend		Folio/f	Program	ļ	Outside	Dimensions	Ш	Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route		Grain			Over/Un	der tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Inco	rreci	Щ	Temperature/Cure
	Crimp/Kii	nk/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	nqualified	Part Lost	/Missing		Weld
[Cuffs				Contamination		Instruc	tions Incomplete/U	Jnclear	Part Mov	/ed		Wrong Stock Pulled
[Crushing				Countersink		Misali	gned/off center		Position	ed Wrong		•
	Heat Trea	at			Cut Too Short		Mislab	eled		Power Lo	oss/Surge	<u></u>	Other
Ī	Inspectio	n Strip in	Tube		Drawing		Misrea	d					
Ī	Marks/Ch	natter			Drill Holes		Off-set						
	Turning S	equence	!		Finish		Out of	Calibration					
Ī	Wave/Tw	vist in Tul	be		Fit/Function		Out of	Sequence		-			

Picklist Print Page 1 September-11-14 12:03:43 PM Work Order ID: 124371 *124371* Parent Item: D3414-041 *D3414-041* Parent Item Name: Lug **Start Date: 9/10/14** Required Date: 9/10/14 Start Oty: 8.00 Required Qty: 8.00 **Comments:** IPP A05.09.13New issueKJ/JLM Component Item ID/ Replacement Mfg/ Bin **Primary** Last Route Unit of Qty on Qty per Kit Total Qty Date Status **Item Name** Item ID Item Location Purch Location Seq ID Measure Hand Qty Issued Issued M304S12GA No Purchased 100 0.155 2 sf 99.8300 DAS 23 *M304S12GA* ** 304/316 0.100" Sheet Location Loc Oty Loc Code MAT019 99.83 113062 76.13 113077 19 m12630 4.7 1.875 D3414-3 Manufactured No 140 Each 62.0000 8

Loc Qty

62

32 30

Location

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14-11-26 MAL

Loc Code

D3414-3

DQA:		Date:	·										DART
QA Closed:		Date:	:		WORK ORDER NON-	-CC	ONFOI	RMANCE / UPI	DAIE	Wo	ork Order up	date only	AEROSPACE
					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Work Orde	er:				, , , ,			CLUB ALLEA	C		1	Water Jet	Engineering
Part N	lo				Rework Scrap			Skid-tube Machining	Crosstube Small Fab		l	d. Eng. Coor.	Quality
NCR N	lo				Use-as-is Suspected Unapproved		Therr	noforming Large Fab	Finishing Composite		Rec/Stol	re/Packaging Supplier	Other
Root				Desci	ription of work order update	ı	nitial	Actio	n		Sign &		
Cause	Dat	e Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion		Date	Verification	QC Inspector
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Equip/Tooling													
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	Centr	e Not Conce	entric		BOM/Route		Grain				Over/Under	tolerance	Set-up
	Crack	S			Broken/Damage/Defect		Hardwa	are			Part Incorre	ci _	Temperature/Cure
	Crimp	/Kink/Rippl	e/Wave		Burrs		Inspect	ion Incomplete/Unq	ualified	<u> </u>	Part Lost/M	issing	Weld
[Cuffs				Contamination		Instruc	tions Incomplete/Un	ıclear		Part Moved	L	Wrong Stock Pulled
	Crush	ing			Countersink		Misali	gned/off center			Positioned V	Vrong _	_
	Heat '	Treat			Cut Too Short		Mislab	eled		L	Power Loss/	'Surge	Other
	Inspe	ction Strip ir	n Tube		Drawing		Misrea	d					
	Mark	s/Chatter			Drill Holes		Off-set						
	Turnii	ng Sequence	9		Finish		Out of	Calibration					
	Wave	/Twist in Tu	be		Fit/Function		Out of	Sequence					

DART AEROSPACE LTD	Work Order: 124371
Description: Lug Bracket	Part Number: D3414-1
Inspection Dwg: D3414 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x	First Article	x	Prototype
	I II ST WITHCH	^	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.313	+0.006/-0.001	. 313	1		V=5km-01	
1.19	+/-0.030	1.19	1			
1.00	+/-0.030	1,00	1			
3.38	+/-0.030	3.38	/			
5.350	+/-0.010	5,350				
6.23	+/-0.030	6.23	7			
2.500	+/-0.010	2500				
0.37	+/-0.030	.37	/			
0.100	+/-0.010	. 101	7			
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	DAS		DAS			

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Measured by:	De	23 9-89	Audite
Date:	14/10	10	

Audited by:	9-89
Date:	14-10-14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Davis and ha	Ammania
Λ	00 00 00		Revised by	Approved
_ ^	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ (a	
С		Dwg Rev updated to Rev C	KJ XD	N.

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	Х	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG

SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 12427 MLJ 14-05-17

BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3) 09.06.17 DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. BT. 3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20. AJS 08.09.23 Α NEW ISSUE 05.03.16 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD

DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. C MFG. APPR. D3414 SHEET 1 OF 3 APPROVED TITLE DE APPR. **LUG ASSEMBLY** NTS

DATE 09.06.17 COPYRIGHT © 2003 BY DART AEROSPACE LTD
THE DOCUMENT IS PRIVATE AND COMPREHING AND IS SUPPLED ON THE DOPIESS COMMITTED IN ANY DIRECT PROMOTION OF COMMITTED TO ANY DIRECT PROMOTION FOR MAINTAINING THE TOTAL OF COMMITTED TO ANY DIRECT PROMOTION FOR MAINTAINING THE TOTAL SECOND TO THE PROMOTION FOR MAINTAINING THE TOTAL SECOND TO THE PROMOTION FOR MAINTAINING THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE TOTAL SECOND THE T

D3414-041 LUG ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER



